

Work Order ID 80589

80589

Page 1

February-23-12 2:49:58 PM

Item ID: D4292-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 24/02/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 24/02/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4292 | C | | | | | | | | |

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 and 12/02/25 5 p
 Jeaspa Bandsaw Cut Blank to 6.250"
 Batch: 12118201
 ****GRAIN DIRECTION MUST BE ALONG 4.00"*****

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1- Memo 0.00 OK/36 12/02/25 5 p
 HAAS CNC vertical machine #1 1-Machine per folio FB002
 DWG REV: C
 FOLIO REV: AA
 2- deburr rough edges

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|---------------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | OK/36 12/2/12 | | 5 | 5 | | |
| 121 *121* Mill Conv Conventional Milling Machine | Memo DRILL & TAP FOR HELICOIL AS PER DWG | 0.00 0.00 | | 12-2-29 | | 5 | | | |
| 122 *122* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | 12-2-29 | | 5 | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---|--------|--------------|---------------|---------------|------------------|--------------------|
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | JL 12-02-27 | | | | | | |
| 140 *140* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | AS 12-3-1 ⑤ | | | | | | |
| 145 *145* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo MASK THREADED HOLE | 0.00 0.00 | Start Time: 9:50 Temp: 320°F Finish Time: 10:20 | | | | | | 5x ✓ M- / 12/03/02 |

M 120222

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NOTE: Date & initial all entries

Work Order ID 80589***80589***

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Item ID: D4292-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 24/02/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 24/02/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

6/3/2 SD(S)

151

0.00

151

Small Fab

Memo

0.00

Small Fab

INSTAL HELICOIL

(5) FF 12-03-15

152

QC5- Inspect part completeness to step on W/O

0.00

152

QC

Memo

0.00

Quality Control

5/1/06

(5)

| W/O: | | WORK ORDER CHANGES | | | | | |
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

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|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------------|
| 180 *180* Packaging Packaging | Identify as per dwg & Stock Location: <u>470</u> Memo | 0.00 0.00 | | | | <u>12/3/6</u> | | | <u>(5)</u> |
| 190 *190* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <u>12/3/6</u> <u>(5)</u> |

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NOTE: Date & initial all entries

Picklist Print

February-23-12 2:50:02 PM

Page 1

Work Order ID: 80589

80589

Parent Item: D4292-1

D4292-1

Parent Item Name: Fitting

Start Date: 24/02/2012

Required Date: 24/02/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD IPP REV

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M7075T73B4.000x4.00 0 | | Purchased | | No | | 100 | f | 20.1465 | 0.52 | 1.642105 | | | |

M7075T73B4 000x4 000

7075-T73 Bar 4.0 x 4.0

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT001 | 5.4055 | |
| 18201 | 5.4055 | |
| MAT005 | 14.741 | |
| 116153 | 0.75 | |
| 116324 | 7.95 | |
| 116764 | 6 | |
| 116867 | 0.041 | |

2.73 on 12/02/25

MS21209F1-10

Purchased

No

Each

72.0000

3

MS21209F1-10

HELI COIL

**

5 FF 12-03-05

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST304 | 72 | |
| 116977 | 72 | |

5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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NOTE: Date & initial all entries

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|-------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 80589 |
| Description: Fitting | | Part Number: | D4292-1 |
| Inspection Dwg: D4292 Rev: C | | Page 1 of 2 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| R0.063 | +/-0.010 | .063 | ✓ | | Over Caliper | OK |
| 0.250 | +0.030/-0.010 | .258 | ✓ | | | |
| 0.125 | +0.030/-0.010 | .131 | ✓ | | | |
| 2.95 | +/-0.030 | 2.954 | ✓ | | | |
| 0.275 | +/-0.010 | .277 | ✓ | | | |
| 0.800 | +/-0.010 | .798 | ✓ | | | |
| 0.825 | +/-0.010 | .823 | ✓ | | | |
| 0.375 | +/-0.010 | .378 | ✓ | | | |
| 0.31 | +/-0.030 | .311 | ✓ | | | |
| 0.88 | +/-0.030 | .885 | ✓ | | | |
| 0.663 | +/-0.010 | .665 | ✓ | | | |
| Ø0.381 | +0.000/-0.001 | .381 | ✓ | | | |
| 1.125 | +/-0.010 | 1.125 | ✓ | | | |
| 1.063 | +/-0.010 | 1.064 | ✓ | | | |
| 3.44 | +/-0.030 | 3.437 | ✓ | | | |
| 2.450 | +/-0.010 | 2.451 | ✓ | | | |
| 1.325 | +/-0.010 | 1.326 | ✓ | | | |
| 0.300 | +/-0.010 | .305 | ✓ | | | |
| 1.200 | +/-0.010 | 1.202 | ✓ | | | |
| 2.84 | +/-0.030 | 2.838 | ✓ | | | |
| 0.19 | +/-0.030 | .194 | ✓ | | | |
| 5.86 | +/-0.030 | 5.862 | ✓ | | | |
| 5.99 | +/-0.030 | 5.990 | ✓ | | | |
| Ø0.272 | +0.006/-0.001 | .274 | ✓ | | | |
| Ø0.266 | +0.006/-0.001 | .266 | ✓ | | | |
| 1.75 | +/-0.030 | 1.752 | ✓ | | | |
| R0.25 | +/-0.030 | .250 | ✓ | | | |
| R0.06 | +/-0.030 | .060 | ✓ | | | |
| 4.875 | +/-0.010 | 4.874 | ✓ | | | |
| 0.493 | +/-0.010 | .497 | ✓ | | | |
| C-bore Ø0.765 | +/-0.010 | .764 | ✓ | | | |
| 0.250 | +0.030/-0.010 | .254 | ✓ | | | |
| 0.680 | +/-0.010 | .684 | ✓ | | | |
| 2.250 | +/-0.010 | 2.250 | ✓ | | | |
| 4.500 | +/-0.010 | 4.505 | ✓ | | | |
| R1.275 | +/-0.010 | 1.275 | ✓ | | | |
| R0.031 | +/-0.010 | .031 | ✓ | | | |

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Dart Aerospace Ltd

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NOTE: Date & initial all entries

Work Order: 80589

FITTING

4292-1

Rev:


2

Page 1 of 1

First Article

X

Prototype

Measured by: 

Date: 12-2-29

Audited by:

Date:

Prototype Approval:

Date:

△

Date _____

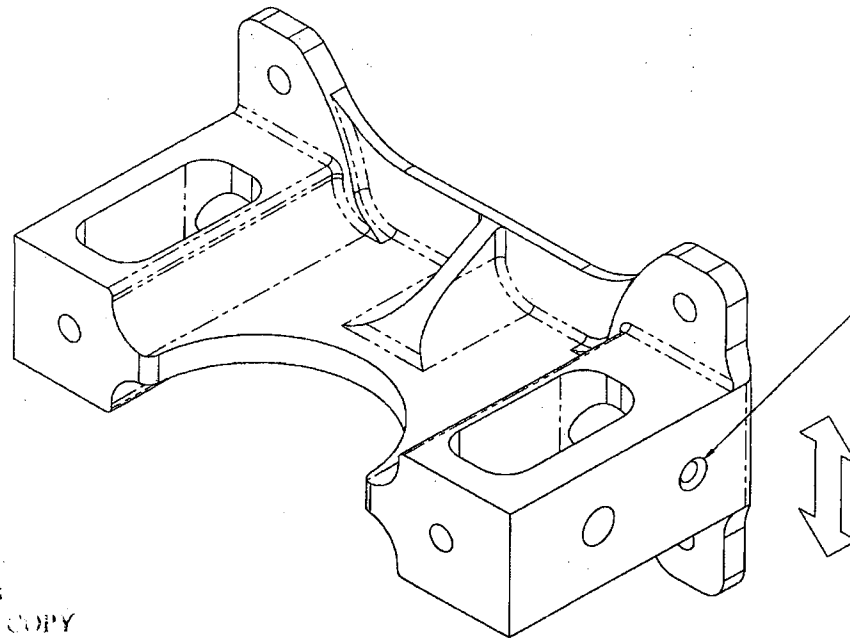
Change

New Issue

Revised by

Approved

KJULM



MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

SEE
WORK ORDER
UNLESS OTHERWISE NOTED
SUBJECT TO AGREEMENT

WORK ORDER
NO. 80589 M.C.J

D4292-1 FITTING

RELEASED
2011-02-01

NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

| C | 1.064 WAS 1.235 (C1-2), ϕ 0.266 WAS ϕ 0.323 (B3-2), ADD HELICAL COIL (D1-2) | CP | 10.12.23 |
|------------|--|----|----------|
| B | 0.800 WAS 0.78 (C8-2), 0.825 WAS 0.81 (C4-2) | CP | 10.11.30 |
| A | NEW ISSUE | CP | 10.11.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.12.23 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4292

REV. C

SHEET 1 OF 3

TITLE

SCALE

FITTING (206L/407 FWD)

NTS

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Dart Aerospace Ltd

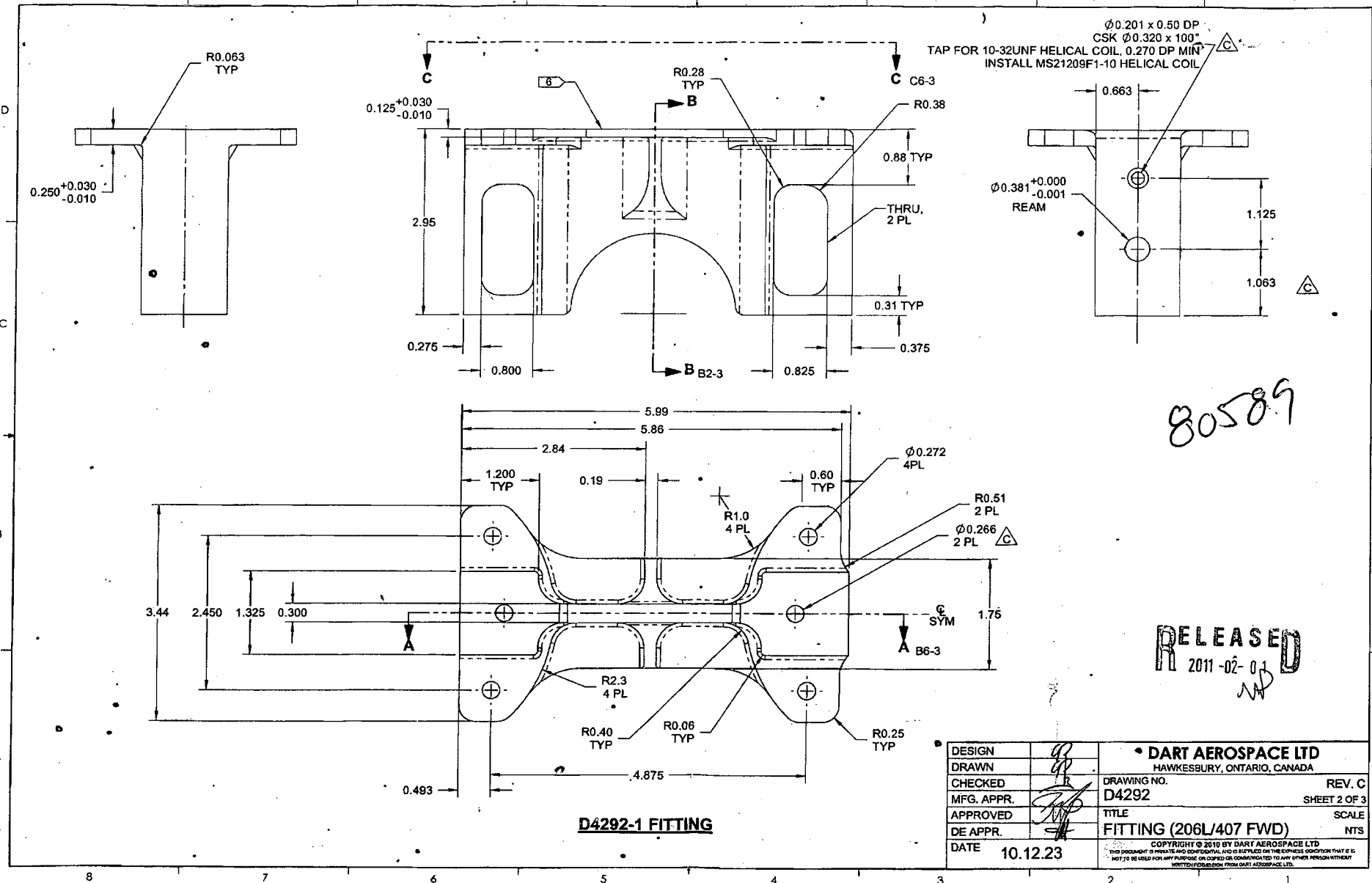
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NOTE: Date & initial all entries



80589

RELEASED
2011-02-03

D4292-1 FITTING

| | | | |
|------------|----------|-------------------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4292 | REV. C |
| MFG. APPR. | | TITLE FITTING (206L/407 FWD) | SHEET 2 OF 3 |
| APPROVED | | SCALE | NTS |
| DE APPR. | | | |
| DATE | 10.12.23 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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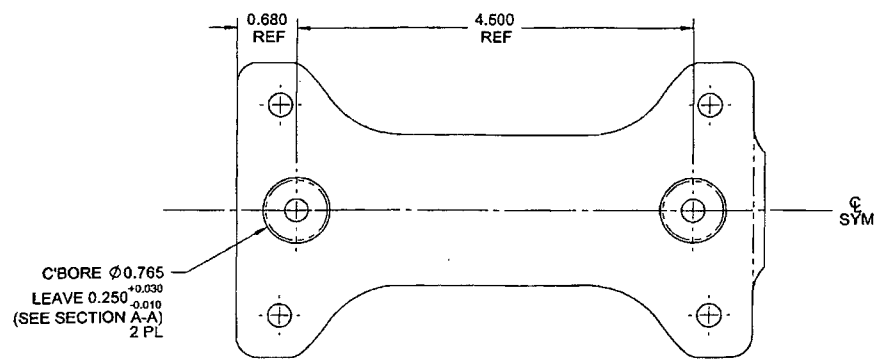
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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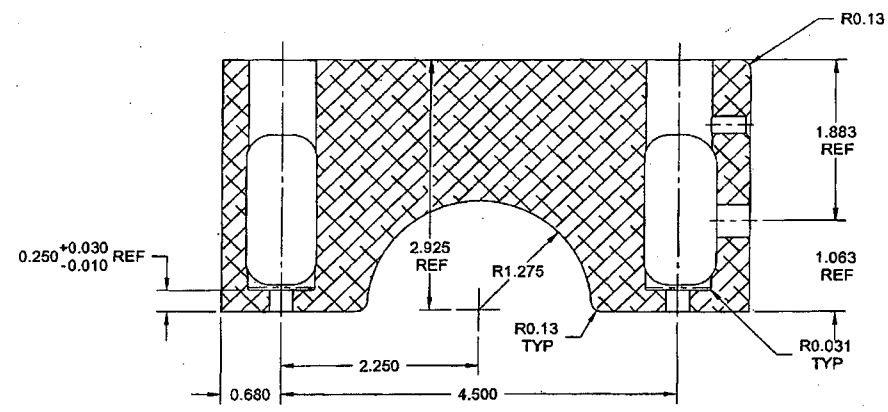
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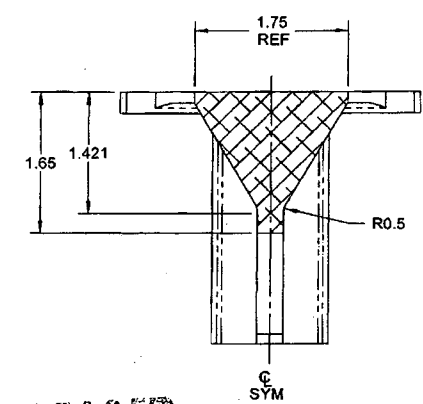
8 7 6 5 4 3 2 1



VIEW C-C D3-2



SECTION A-A A3-2



SECTION B-B C4-2

RELEASED
2011-02-01

| | | |
|------------|-----------------|---|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4292 REV. C |
| MFG. APPR. | | SHEET 3 OF 3 |
| APPROVED | | TITLE FITTING (206L/407 FWD) SCALE NTS |
| DE APPR. | | |
| DATE | 10.12.23 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|--------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr. | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries